



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

APR 26 2018

D412-698-023
Job Sheet 176596



002844

Part No: D412-698-023

Job Qty: 2 ea

Part Name: Automatic Door Opener (fits LH or RH)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/26/18

Job Tracking No:

Due Date: 5/11/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: IIN-D412-698 REV.G IPP Rev:A New Issue 07-07-12 JLM IPP rev B ecn 1207 08.07.03 EC verified by:LL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	2 Ea		5/11/18	0.00	0.00	Start Up Stores/Pkg-2		APR 26 2018
110	Packaging	2 pcs		5/11/18	0.00	0.00	Packaging1-4		MAY 08 2018
120	QC	2 pcs		5/11/18	0.00	0.00	QC4		Smb
125	DC	2 pcs		5/11/18	0.00	0.00	DC		Smb
130	Packaging	2 pcs		5/11/18	0.00	0.00	Packaging3-2		MAY 08 2018
140	QC21-FG	2 Ea		5/11/18	0.00	0.00	QC21		fg

Part Op 125 - Photocopy bluefile & type labels per PPP D412-698-023 CHG003
Descriptions:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3552-11	Door Prop	2 Ea (1 ea)	90-Start up Operation	S055045
D3594-043	Floor Doubler Assembly, LH	2 Ea (1 ea)	90-Start up Operation	S059003x2
D3594-044	Floor Doubler Assembly, RH	2 Ea (1 ea)	90-Start up Operation	S063806
D3594-5	Doubler	2 Ea (1 ea)	90-Start up Operation	S042090
D3622-1	Ball Stud	4 Ea (2 ea)	90-Start up Operation	S053568
MS20426AD4-4	Rivet	4 Ea (2 ea)	90-Start up Operation	FM132536
MS21073L5	Anchor Nut	2 Ea (1 ea)	90-Start up Operation	S036488
NAS1149D0516J	Washer	4 Ea (2 ea)	90-Start up Operation	S007015

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3552-11	2	11	0
	D3594-043	2	19	0
	D3594-044	2	7	0
	D3594-5	2	14	0
	D3622-1	4	12	0
	MS20426AD4-4	4	1,224	0
	MS21073L5	2	26	0
	NAS1149D0516J	4	188	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description Wor _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
		MRB (QSI042) Approval _____ Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																			

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DART
 AEROSPACE

Container No: S069300
 Part: D412-698-023
 Job No: 176596
 Serial No/Batch: S069300
 Revision: G
 Inspector: _____

Date: 06/08/18

Root Cause			
Environment ☐	No Re-verification ☐		
Design ☐	Operator ☐		
Doc/Data ☐	Offset/Setup ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐	OTHER : _____	

ge ☐ Positioned Wrong
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Drawing
☐ Finish
☐ Misread
☐ Turning Sequence

Part Specifications
Specifications could not be found.

Plex 4/26/18 10:38 AM dart.lacelle.linda

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

7.0 PARTS LIST – PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		NAS1149D0332J	WASHER (AN960JD10L)
	2	NAS1149D0516J	WASHER (AN960JD516L)
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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Revision: G

Date: 17.11.23

Part Number: D412-698-023

Description: AUTOMATIC DOOR OPENER INSTALLATION

[illegible]

DQA: _____ Date: _____



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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
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OTHER : _____					